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D350-591-311
Job Sheet 186613



Part No: D350-591-311

Job Qty: 10 ea

Part Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/19/18

Job Tracking No: AIRBUS

Due Date: 12/21/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3272-1 JLM IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		12/21/18	0.00	0.00	Start Up Large Fab-4		LC
110	Large Fab	10 pcs		12/21/18	0.00	9.91	Large Fab 2		LC
120	QC	10 pcs		12/21/18	0.00	0.00	QC9		CPL
130	QC	10 pcs		12/21/18	0.00	0.00	QC5		CPL
140	HandFinish	10 pcs		12/21/18	0.00	1.84	HandFinish1		DR 18/11/21
150	QC	10 pcs		12/21/18	0.00	0.00	QC7-2		CPL
180	Large Fab	10 pcs		12/21/18	0.00	9.91	Large Fab 2		LC DAS
190	QC	10 pcs		12/21/18	0.00	0.00	QC10		38 DAS
200	QC	10 pcs		12/21/18	0.00	0.00	QC5		9-89 38
210	HandFinish	10 pcs		12/21/18	0.00	1.84	HandFinish1		DR 18/11/26
220	Powdercoat	10 pcs		12/21/18	0.00	2.90	Powdercoat1		DEC 17 2018
230	HandFinish	10 pcs		12/21/18	0.00	1.84	HandFinish3		LC 12/11/2018
240	QC	10 pcs		12/21/18	0.00	0.00	QC3		NOV 30 2018 68
250	Packaging	10 pcs		12/21/18	0.00	0.00	Packaging1-3		DAS
260	QC	10 pcs		12/21/18	0.00	0.00	QC4		DEC 17 2018 DAS 69
270	Packaging	10 pcs		12/21/18	0.00	0.00	Packaging3-1		DEC 17 2018 69 9-89
275	DC	10 pcs		12/21/18	0.00	0.00	DC		DAS 9-89 DEC 17 2018
280	QC21-FG	10 Ea		12/21/18	0.00	0.00	QC21		21 DAS DEC 17 2018

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod 138872 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: 2:40 OVEN TEMPERATURE: 320 FINISH TIME: 3:10

270 - Identify and pack for shipping as per PPPD350-591-311 Location : FG109

275 - Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	20 Ea (2 ea)	90-Start up Operation	5125543
D3219-1	Plate	20 Ea (2 ea)	90-Start up Operation	5108646/5125734x1
D3272-1	Step	10 Ea (1 ea)	90-Start up Operation	5129268

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:25%;">Skid-tube ☐</td> <td style="width:25%;">Cross tube ☐</td> <td style="width:25%;">Water Jet ☐</td> <td style="width:25%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause		FAULT CATEGORY	
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐
		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____			

D3065-041	Step Leg Assembly	9 10 Ea (1 ea)	180-Large Fab	5127961
D3066-1	Spacer	18 20 Ea (2 ea)	180-Large Fab	16x5113167/4x128757
MS20600-AD4W4	Rivet	144 160 Ea (16 ea)	180-Large Fab	5117999
AN3-35A	Bolt	18 20 Ea (2 ea)	250-Packaging	5101329
AN4-13A	Bolt	72 80 Ea (8 ea)	250-Packaging	5115326
AN5-36A	Bolt	18 20 Ea (2 ea)	250-Packaging	5099504
D2230-3	Mounting Lug	3137811x28 38 40 Ea (4 ea)	250-Packaging	5130628x13
D2618	Bushing	18 20 Ea (2 ea)	250-Packaging	5118035
D2856-400-720	Abrasion Strip 4" X 7.20"	18 20 Ea (2 ea)	250-Packaging	5104554
D3235-1	Mounting Lug	18 20 Ea (2 ea)	250-Packaging	5113205
D3278-041	Support Assembly	9 40 Ea (1 ea)	250-Packaging	511822
MS21042L3	Nut	18 20 Ea (2 ea)	250-Packaging	5094592
MS21042L4	Nut	72 80 Ea (8 ea)	250-Packaging	5109736
MS21042L5	Nut	18 20 Ea (2 ea)	250-Packaging	5093592
NAS1149D0363J	Washer	36 40 Ea (4 ea)	250-Packaging	5107782
NAS1149D0463J	Washer	144 160 Ea (16 ea)	250-Packaging	5092780
NAS1149D0563J	Washer	96 40 Ea (4 ea)	250-Packaging	3050053

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	20	260	0
	D3219-1	20	219	0
	D3272-1	10	1	0
180-Large Fab	D3065-041	10	21	0
	D3066-1	20	350	0
	MS20600-AD4W4	160	2,558	0
250-Packaging	AN3-35A	20	253	0
	AN4-13A	80	950	0
	AN5-36A	20	116	0
	D2230-3	40	68	0
	D2618	20	169	0
	D2856-400-720	20	186	0
	D3235-1	20	109	0
	D3278-041	10	43	0
	MS21042L3	20	1,721	0
	MS21042L4	80	1,882	0
	MS21042L5	20	423	0
	NAS1149D0363J	40	2,068	0
	NAS1149D0463J	160	2,662	0
	NAS1149D0563J	40	1,308	0

Part Specifications

Specifications could not be found.

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No. _____	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
NCR No. _____	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		☐

Date :	Star #:	QTY Effective :	MRB (QSI042) Approval
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11/19/18
181603

Disposition

Completed By

Lead hand / Supervisor
Approval Verification

**QC / QA Coordinator
Approval**

FAULT CATEGORY

Power Loss/Surge
Folio/Program
Grain
Weld
Wrong Stock Pulled
Out of Sequence
Off-set
Mislabeled
Fit/Function
Misaligned/off center

Positioned Wrong
Outside Dimensions
Over/Under tolerance
Part Incorrect
Part Lost/Missing
Part Moved
Drawing
Finish
Misread
Turning Sequence

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Container No: S129403

Part: D350-591-311

Job No: 186613

Serial No/Batch: S129403

Revision: _____
Inspector: _____
Exp Date: _____

Instructions: TC STC SH92 - 6 Issue 1_{date} FA₂₀₀₄ STC SH967NE 04/12/21, BRAZIL 1

Part No. 0322-1
Serial No. B101-312929

Rev. 8/2007

Change No.

Change Record

PAGE 1 OF 2

Part Number: D350-591-311/-312 (EURO P/N: 704A 41 640 012/-011)

Description: HELI-ACCESS STEP, HIGH SKID, LONG STEP, LH/RH

[illegible]

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
	X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
		X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
			X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
				X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
					X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.

REFERENCE ONLY

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